Work	Order	ID	70819
VVUIN	Oluci	117	/ 001/

Page 1

Wednesday, June 15, 2011 2:27:34 PM Item ID: D3463-5

Accept

Setup Start

Stop



Revision ID:

End Cap Item Name:

Required Date: 6/22/2011

6/15/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Date://-0/-

Date:

Tooling: SPC (Y/N):

Date: Date:

Start Run

Stop

Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

OC:

D3463

Rev B

100

Waterjet

FLOW WATER JET

Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

1B(1-6-02

FLOW CNC Waterjet

304,063

Memo

1-Cut as per Dwg D3463

□Dwg Rev:

□Prog Rev: S □2-

110

0.00

Quality Control

Memo

0.00

B11-6-22

120

QC8- Inspect parts - second check

Quality Control

Memo

Dan Aerospace Lic	t Aerospace Ltd	į	
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W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							<u> </u>		
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	
	Re	solution:	Disposition	:	QA: N/C Cld	sed:		Date: _	
NCR:		1	WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE STEP	STED	STEP Description of NC Section A	Corrective Action Section B			Verification		Approval	Approval
	SIEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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Work Order ID 70819

Page 2

Wednesday, June 15, 2011 2:27:34 PM

Required Date: 6/22/2011

Item ID: **Revision ID:** D3463-5

Accept



Setup Start



Item Name: **Start Date:**

End Cap 6/15/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID: Customer:

Tool ID

Stop

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

*****STOCK IN LARGE FAB*****

Set Up/ **Run Hours** 0.00

0.00

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Tool # Plan Code

Accept **Qty**

Reject Qty

Run

Reject Insp. Stamp Number

MF (1-06-23

	Johnson								
W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:PA		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	l:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)		· .	,
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descript		າ Sign & _S		erification Approval Section C Chief Eng		Approval QC Inspector
			Chief Eng	Chief Eng	Date	, ,			
	,								

Picklist Print

Wednesday, June 15, 2011 2:27:41 PM

Work Order ID: 70819

Parent Item:

D3463-5

Parent Item Name: End Cap



Start Date: 6/15/2011

Required Date: 6/22/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV. A 05.11.18 NEW ISSUE

IPP Rev:B Now on Waterjet 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	69.7000	0.014	0.176842	1,		
										1R11-	(-77		

304/316 Sheet .063

<u>Location</u>	Loc Oty	Loc Code		(3)
MAT020	69.7			
117275	2.3	• ;	<u></u>	. –
117653	67.4	•	117653	

	Johann								
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				· · · · · · · · · · · · · · · · · · ·					
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A :	Date: _	
	Re	esolution:	Dispositi	on:	QA: N/C C	closed:		Date:	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B			cation	Approval App	Approval
- DAIL	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
			·						

D3065-5DART AEROSPACE LTD	Work Order:	10819
Description: End Cap	Part Number:	D3463-5
Inspection Dwg: D3463 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X First Art	icle	Prot	otype
Drawing	 Actual		Deinat	Method

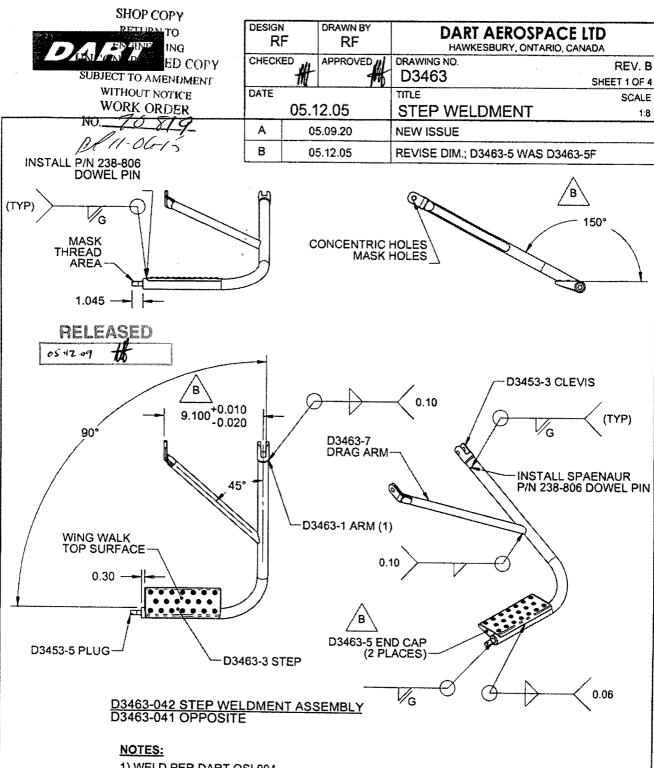
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.15	+/-0.030	155	×		U 1802	
0.10	+/-0.030	,107	>		U	
R0.17	+/-0.030	,17	8		R.G	
R0.50	+/-0.030	. 50	æ		R.G	
0.58	+/-0.030	,৬১	5		1	
		•			,	

Measured by:	iB	Audited by:	8	Prototype Approval:	N/A
Date:	11-6-37	Date:	1/06/172	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	06.07.11	New Issue	· ·	KJ/JLM 🚓	E
				· · · · · · · · · · · · · · · · · · ·	

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W/O:			W	ORK ORDER CHANG	iES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
:									
Part No		PAR #:							
	Re	esolution:						Date: _	
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NCF	?)			
DATE	STEP	Description of NC			tion B	Verific	cation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Approval Chief Eng	QC Inspector
			·						
•							_		
									
	1							1	

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



- 1) WELD PER DART QSI 004
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

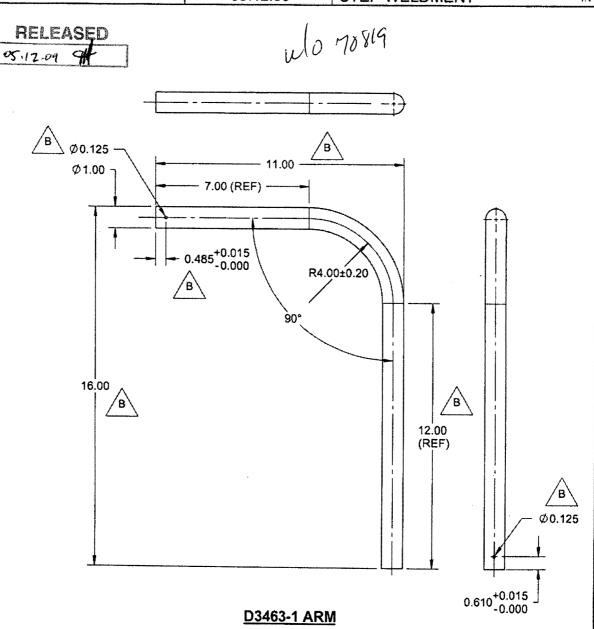
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W/O:	, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		WC	ORK ORDER CHANGI	ES					
Part No: Resolution:	PRO	OCEDURE CHA	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									· · · · · · · · · · · · · · · · · · ·	
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date			_ Date:		
Resolution:			Disposition:			QA: N/C Closed:				
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC	Section A Initial Action Description Sign & Section C Chief Eng	Approval	Approval					
DATE	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		in & ate	Secti	on C		QC Inspector
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DESIGN RF	DRAWN BY RF	DART AEROSPAC HAWKESBURY, ONTARIO,	
CHECKED	APPROVED	DRAWING NO.	REV. B
T	- TIM	D3463	SHEET 2 OF 4
DATE		TITLE	SCALE
l 05.1	2.05	STEP WELDMENT	1:4



NOTES:

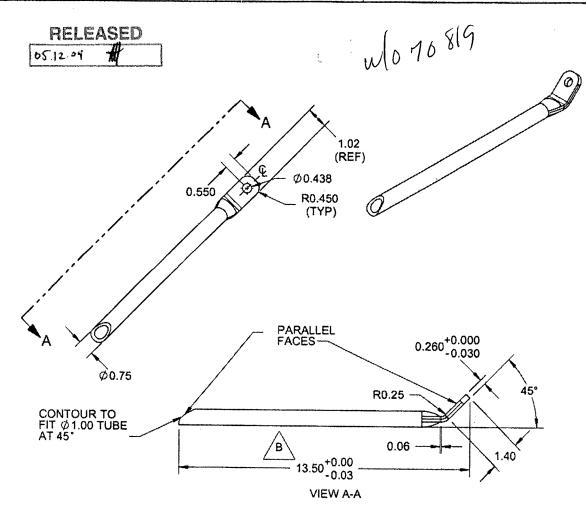
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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W/O:			W	ORK ORDER CHANG	ES		,				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	y Date Qty Approval Chief Eng / Prod Mgr			Approval QC Inspector		
Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA:		_ Date: _			
	Re	esolution:	Disposition	on:	_ QA: N/C CI	osed:					
NCR:		V	WORK ORD	ER NON-CONFORMA	ANCE (NCF	l)					
DATE	STEP	Description of NC	Corrective Action Section B		Verifica	tion	Approval	Approval			
Part No: _	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	Section C		QC Inspector		
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 3 OF 4			
DATE 05.1	12.05	STEP WELDMENT	SCALE 1:4			



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

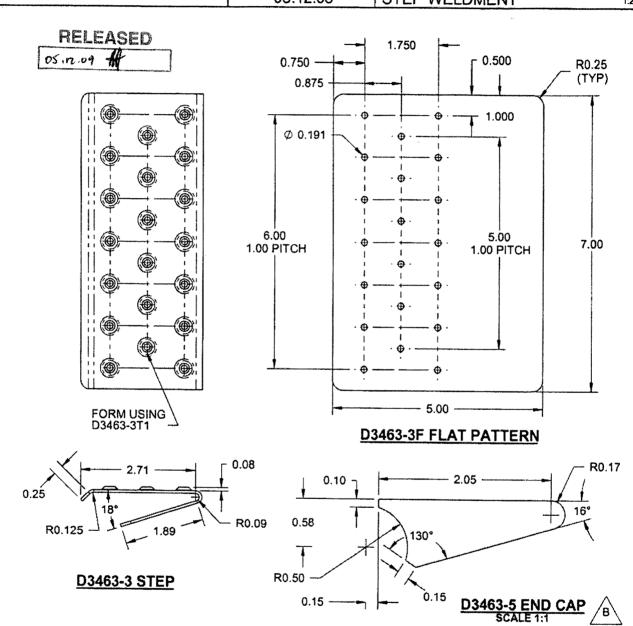
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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQ.	A:	Date: _	
	Re	esolution:	Dispositio	n:	QA: N/C	Clos	ed:		Date: _	
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NCR:	STEP	Description of NC			tion B		Verific	ation	Approval	Approval
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n & ate	Secti	on C	Chief Eng	QC inspector
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED #	APPROVED	D3463	REV, B			
114			SHEET 4 OF 4			
DATE		TITLE	SCALE			
05.1	12.05	STEP WELDMENT	1:2			



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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W/O:			WC	RK ORDER CHANG	ES				
DATE STEP		PRO	CEDURE CHAI	NGE	By Date (Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:		solution:	Disposition:		_ QA: N/C CI	osed:		Date: _	
NCR:		V	VORK ORDE	ER NON-CONFORMA	NCE (NCR	3)			
DATE	STEP	Description of NC	L	Corrective Action Section		Verifi	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sec	tion C	Chief Eng	QC Inspector
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